



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

May 15
D3438-042
Job Sheet 176551



Part No: D3438-042

Job Qty: 2 ea

Part Name: Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/25/18

Job Tracking No:

Due Date: 5/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.05.18 New Issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		5/11/18	0.00	0.00	Start Up Large Fab-4		<i>h.M.L 18-4-30</i>
100	Large Fab	2 pcs		5/11/18	0.00	2.56	Large Fab 2		<i>SL</i>
110	QC	2 pcs		5/11/18	0.00	0.00	QC9		<i>CPL</i>
120	QC	2 pcs		5/11/18	0.00	0.00	QC5		<i>CPL</i>
130	HandFinish	2 pcs		5/11/18	0.00	0.97	HandFinish1		<i>SA 18-05-07</i>
140	QC	2 pcs		5/11/18	0.00	0.00	QC3		<i>CPL</i>
150	Large Fab	2 pcs		5/11/18	0.00	2.56	Large Fab 2		<i>CPL</i>
160	QC	2 pcs		5/11/18	0.00	0.00	QC10		<i>SA 2018-05-10</i>
170	QC	2 pcs		5/11/18	0.00	0.00	QC5		<i>SA 2018-05-10</i>
175	HandFinish	2 pcs		5/11/18	0.00	0.20	HandFinish6		<i>SA 18-05-10</i>
180	Powdercoat	2 pcs		5/11/18	0.00	0.28	Powdercoat1		<i>BR 18-5-10</i>
190	HandFinish	2 pcs		5/11/18	0.00	0.97	HandFinish3		<i>BR 18-05-11</i>
200	QC	2 pcs		5/11/18	0.00	0.00	QC3		<i>38</i>
210	Packaging	2 pcs		5/11/18	0.00	0.00	Packaging3-1		<i>DA 9-89 21</i>
220	QC21-SA	2 Ea		5/11/18	0.00	0.00	QC21		<i>38</i>

Part Op 100 - 1-Cut D2244 to 79.63" at 34° as per Dwg D3438 3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg Descriptions: D3438 using DT8343 4-Grind

150 - Weld last cap per dwg D3438 & grind flush

175 - Touch up alodine

180 - 1-Touch up alodine

190 - Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs

M 138760 START: 1:10 OUT: 3:30 FINISH: 1:40

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	<i>5014552</i>
D2561	Lug	4 Ea (2 ea)	90-Start up Operation	<i>5063397</i>
D2673-34	End Plate	4 Ea (2 ea)	90-Start up Operation	<i>3052885</i>
D2564	Mounting Angle	4 Ea (2 ea)	90-Start up Operation	<i>5052121</i>

Wing walk M138761

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	2	147	0
	D2561	4	12	0
	D2564	4	11	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
DART Aerospace Ltd. 1270 Aberdeen Street, 1K7 Hamilton, ON K6A 1K7 CANADA TEL: 905-573-5200 Email: sales@dartaero.com www.dartaerospace.com		Date: 04/30/18		Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ Container No: S067064 Part: D3438-042 Job No: 176551 Serial No/ Batch: S067064 Revision: _____ Inspector: _____		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			
Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : _____		Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			

Part Specifications

Specifications could not be found.

Plex 4/25/18 2:51 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					